

Date: Wednesday, 29/10/2008 10:45:51 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACEPOD UPGRADE KIT
Job Number : 43068	
Estimate Number : 13203	
P.O. Number :	Part Number : D350600149
This Issue : 29/10/2008 S.O. No. :	Drawing Number : N/A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 37673	Material :
Written By :	Due Date : 30/10/2008 Qty: 1 Um: Each
Checked & Approved By :	
Comment : Est Rev:A new issue 08-03-04 DD verified by: LL	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: Photocopy bluefile & type labels per PPP 350-600-149 CHG001

508/6/29

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

3.0	D35547	Ball Stud
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

BALL STUD

Batch: 37674

SS 08/10/29 (X)

4.0	D35481	Bracket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BRACKET

batch 30245

SS 08/10/29 (X)

5.0	D30153	Locknut
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Lock Nut

batch 41898

SS 08/10/29 (X)

Process Sheet

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Drawing Name: SPACEPOD UPGRADE KIT

Job Number: 43068

Part Number: D350600149

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	D35529	Door Prop
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CARBON STEEL GAS SPRING

batch 30673

SS 08/10/29 @

7.0	D35491	Bracket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BRACKET

batch B3125

SS 08/10/29 @

8.0	D35383	Hinge Bracket
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

HINGE BRACKET

batch 30246

SS 08/10/29 @

9.0	AN526C832R14	Screw
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

Batch: 9214

SS 08/10/29 @

10.0	MS270390811	Screw
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

Batch: M108335

SS 08/10/29 @

11.0	AN960JD516	Washer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M109059

SS 08/10/29 @

12.0	NAS1515H3	Washer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M107101

SS 08/10/29 @

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Drawing Name: SPACEPOD UPGRADE KIT

Job Number: 43068

Part Number: D350600149

Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	MS21042L08	Nut
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Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Nut

Batch:

M108928

SS 08/10/29 (X)

14.0	AN960JD8	Washer
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Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Washer

Batch:

M108335

SS 08/10/29 (X)

15.0	AN526C832R10	Screw
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

Batch:

M104603

SS 08/10/29 (X)

16.0	MS20426AD45	Rivet
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Rivet

Batch:

M3459

SS 08/10/29 (X)

17.0	MS20426AD46	Rivet
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Rivet

batch

M05144

SS 08/10/29 (X)

18.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

SS 08/10/29 @

19.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-600-149

Location:

PPP Rev:

Draft

8/10/29

(X)

SL

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User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD UPGRADE KIT

Job Number: 43068

Part Number: D350600149

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/30 [Signature]

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-10-29

52.4 PARTS LIST

589 -011	589 -041	589 -042	589 -043	Part Number	Description
X				D350-589-011	SIDE DOOR LATCH MODIFICATION KIT
	X			D350-589-041	SIDE DOOR ASSEMBLY, LH AS 350
		X		D350-589-042	SIDE DOOR ASSEMBLY, RH AS 350/355
			X	D355-589-043	SIDE DOOR ASSEMBLY, LH AS 355
				D2991-1	Door
		1		D2991-2	Door
			1	D2991-3	Door
3	✓ 3	3	3	D2237	Striker Plate
	✓ 1	1	1	D2464-1700	Seal
3	✓ 3	3	3	D2583	Latch Bracket
3	✓ 3	3	3	D2585	Latch Clamp
3	✓ 3	3	3	D2586	Latch
1	✓ 1	1	1	D2587	Plug
1	✓ 1	1	1	D2589	Keys, Key Chain
	✓ 3	3	3	D2621	Latch Plate
	12**	2**	2**	D2992-1	Doubler
	1	1	1	D3085-041	Prop Assembly
	1*	1*	1*	D30153	Locknut
	1*	1*	1*	D3081-1	Prop Hinge
	1*	1*	1*	D3082-1	Clip
	1*	1*	1*	D3084-1	Prop Arm
	1*	1*	1*	AN4-5A	Bolt
	3*	3*	3*	AN960JD10	Washer
	3*	3*	3*	AN960JD10L	Washer
	2*	2*	2*	AN960JD416	Washer
	1*	1*	1*	AN960JD516L	Washer
	3*	3*	3*	MS21042L3	Nut (or MS21042-3)
	1*	1*	1*	MS21042L4	Nut (or MS21042-4)
	3*	3*	3*	MS27039-1-13US	Screw
	1*	1*	1*	SL68-B5	Ball Stud
	6	6	6	AN3-4A	Bolt
3	3	3	3	AN960JD10	Washer
3	9	9	9	MS21042L3	Nut (or MS21042-3)
6	6	6	6	MS20470AD4-5	Rivet
3	3	3	3	MS27039-1-15	Screw

* Reference only. Included in D3085-041 Prop Assembly listed above.

** Reference only. Included in D2991-1/-2/-3 Doors listed above.

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Mo 43068

sb

8/10/24

Date : Wednesday, 29/10/2008 2:49:25 PM

User : Linda Lacelle

ESTIMATING - DETAIL QUOTATION

Estimate No. :	12295	Date Entered :	16/02/2006
Customer :	CU-DAR001 Dart Helicopters Services	SLS Person :	
R.F.Q. Number :	CHG002	Target Date :	16/02/2006
Part Number :	D350589041	Accepted :	21/02/2006
Drawing Name :	SIDE DOOR	Last Job No. :	42908
Project # :	N/A	Class :	DAPURC
Drawing # :	D2991 REV.C		
Quantities :	Each	1	0
Scrap Allowed :		0.00	0.00
Material :			
Comment :	est rev. A 06.02.16 new issue (was done on D350-589-041) EC Est Rev:B 08-02-20 ECN 1096 DD verified by:EC est rev C 08.06.26 Revised pik list per QC comment (w/o 25885) EC verified: DD		
#	DESCRIPTION	TYPE	DETAIL : Cost Per Unit * Units (Sub-Com.,Inv. Item,Ext OP.) TOTAL COST \$ 1/0.00 0/0.00 0/0.00 0/0.00
1	917 DC	Int. OP.	S: 0.00h/R: 0.00h \$0.00
2	900 OUTSIDE SERVICE	Ext. OP.	\$0.00*1.00 \$0.00
3	711 PACKAGING 1	Int. OP.	S: 0.00h/R: 0.00h \$0.00
4	918 QC6	Int. OP.	S: 0.00h/R: 0.00h \$0.00
5	D29911	Inv. Item	\$0.00*1.00 \$0.00
6	D24641700	Inv. Item	\$0.00*1.00 \$0.00
7	D2585	Inv. Item	\$2.83*3.00 \$8.50
8	D2586	Inv. Item	\$12.94*3.00 \$38.81
9	D2621	Inv. Item	\$8.91*3.00 \$26.72
10	D3085041	Inv. Item	\$0.00*1.00 \$0.00
11	AN960JD10	Inv. Item	\$0.04*3.00 \$0.12
12	MS21042L3	Inv. Item	\$0.10*6.00 \$0.63
13	MS27039115	Inv. Item	\$0.12*3.00 \$0.36
14	111 SMALL FAB 1	Int. OP.	S: 0.00h/R: 0.00h \$0.00
15	919 QC5	Int. OP.	S: 0.00h/R: 0.00h \$0.00

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ESTIMATING - DETAIL QUOTATION

Estimate No. : 12295

Part Number : D350589041

#	DESCRIPTION	TYPE	DETAIL Cost Per Unit * Units (Sub-Com., Inv. Item, Ext OP.) OR Setup (hrs)/Total Run(hrs) (Int. OP.)			
			TOTAL COST \$			
			1/0.00	0/0.00	0/0.00	0/0.00
16	711 PACKAGING 1	Int. OP.	S: 0.00h/R: 0.00h			
			\$0.00			
17	D2237	Inv. Item	\$2.08*3.00			
			\$6.24			
18	D2589	Inv. Item	\$3.49*1.00			
			\$3.49			
19	AN34A	Inv. Item	\$0.07*6.00			
			\$0.43			
20	MS20470AD45	Inv. Item	\$0.01*6.00			
			\$0.06			
21	MS21042L3	Inv. Item	\$0.15*3.00			
			\$0.44			
22	711 PACKAGING 1	Int. OP.	S: 0.00h/R: 0.00h			
			\$0.00			
23	1012 QC21	Int. OP.	S: 0.00h/R: 0.00h			
			\$0.00			

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ESTIMATING - DETAIL QUOTATION

Estimate No. : 12295

Part Number : D350589041

Total Time	0.00			
Sub Components	\$0.00			
Material Cost	\$85.79			
Setup Cost	\$0.00			
Run Cost	\$0.00			
Scrap Run Cost	\$0.00			
Sub-Contract Cost	\$0.00			
Total Cost	\$85.79			
Cost Per Unit	\$85.79			
Markup Material	67.00%			
Markup Shop/OP.	67.00%			
Markup Subcontract	67.00%			
Currency Exchange USD	1.2000			
Quoted /Unit	\$143.26			
Final Each	\$119.39			
Final Quoted	\$119.39			
Gross Profit	40.12%			

Sent Via : On : / / By : To :

Written by _____ Approved by _____ Delivery _____ Date _____